

Work Order ID 86578

86578

Page 1

July-05-12 1:10:17 PM

Item ID: D350-600-249 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacepod Upgrade
 Start Date: 7/05/12 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/09/12 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: CL Date: 12/07/05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev C								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP 350-600-249 CHG001								
110		0.00							
110	Packaging								
Packaging	Memo	0.00							
Packaging	Packaging								
120		0.00							
120	QC4- 100% Inspect kits for completeness								
QC	Memo	0.00							
Quality Control									

ML5 12/08/30

2

12/08/29/B

8

DA
16

17608/30
JB

DA
16

17608/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86578***86578***

Page 2

July-05-12 1:10:17 PM

Item ID: D350-600-249

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacepod Upgrade

Start Date: 7/05/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/09/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-600-249

Location: _____

PPP Rev: B

2x

BP

12-8-30

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 12/08/30

MLJ 12/08/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 86578

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 7/05/12

Required Date: 7/09/12

Start Qty: 2.00


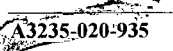














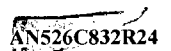













Required Qty: 2.00

Comments: IPP Rev:A new issue 07.01.31 EC

IPP Rev:B 11.02.07 added missing
IPP

AN960JD8 washer DD verf:JLM

REV:A 11.04.27 added 1 D3554-7 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
  A3235-020-935 Washer - Countersunk		Purchased	No			120	Each	314.0000		2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST280		314							
				106150		314							
  AN526C832R10 Screw		Purchased	No			120	Each	103.0000		20			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST347		103							
				115101		5							
				118853		98							
  AN526C832R14 Screw		Purchased	No			120	Each	396.0000		12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST348		396							
				104916		396							
  AN526C832R24 screw		Purchased	No			110	Each	85.0000		8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST348		85							
				118870		85							
  AN5-5A Bolt		Purchased	No			120	Each	57.0000		2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST337		57							
				110865		57							
  AN960JD10 Washer	NAS1149D0363J	Purchased	No			120	Each	0.0000		2		12/08/29	

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 2

Work Order ID: 86578

Parent Item: D350-600-249

Start Date: 7/05/12

Required Date: 7/09/12

Parent Item Name: Spacepod Upgrade

Start Qty: 2.00

Required Qty: 2.00

AN960JD10L

NAS1149D0332J

Purchased

No

120

Each

0.0000

Washer

AN960JD516

NAS1149D0563J

Purchased

No

120

Each

12.0000

Washer

Location

Loc Qty

Loc Code

ST338

12

2612

12

AN960JD8

NAS1149DN832J

Purchased

No

120

Each

0.0000

Washer

D2228

Manufactured

No

120

Each

41.0000

Bracket Plate

Location

Loc Qty

Loc Code

ST008

41

64427

3

73380

38

D2237

Manufactured

No

120

Each

62.0000

Striker Plate

Location

Loc Qty

Loc Code

ST006

42

64426

2

66139

1

82062

3

83376

36

ST009

20

85476

20

D2464

Manufactured

No

120

f

560.4206

3/4 Seal

(D2464-0360) cut (1) at 36.00" per kit

Location

Loc Qty

Loc Code

ST404

560.4206

61878

83.6406

83543

476.78

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 86578

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 7/05/12

Required Date: 7/09/12

Start Qty: 2.00

Required Qty: 2.00

D3015-3

Locknut

Manufactured No

120 Each 394.0000

2

4

23

SP

Location

Loc Qty

Loc Code

ST023

394

78314

94

83565

300

83565

2

4

23

SP

D3538-1

Hinge Bracket

Manufactured No

120 Each 19.0000

2

4

23

SP

Location

Loc Qty

Loc Code

ST054

19

84029

7

84630

12

84029

1

2

23

SP

D3547-1

Bracket

Manufactured No

120 Each 15.0000

1

2

23

SP

Location

Loc Qty

Loc Code

ST054

15

67604

1

83113

14

1X 67604

1X 83113

69053

1

2

23

SP

D3550-1

Strut

Manufactured No

120 Each 12.0000

1

2

23

SP

Location

Loc Qty

Loc Code

ST271

12

69040

2

83114

10

69040

1

2

23

SP

D3552-7

Door Prop

Manufactured No

120 Each 22.0000

1

2

23

SP

Location

Loc Qty

Loc Code

ST272

22

73382

4

83115

10

85044

8

85044

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 4

Work Order ID: 86578
Parent Item: D350-600-249
Parent Item Name: Spacepod Upgrade

Start Date: 7/05/12

Required Date: 7/09/12

Start Qty: 2.00

Required Qty: 2.00

D35547
Ball Stud

Manufactured No

120 Each 9.0000

2

4 JB

Location

Loc Qty

Loc Code

ST054

9

73383

9

73383

D35571
Bracket

Manufactured No

120 Each 22.0000

1

2 JB

Location

Loc Qty

Loc Code

ST054

22

73384

22

73384

MS20426AD4-5
Rivet

Purchased No

120 Each 4,611.0000

2

4 JB

Location

Loc Qty

Loc Code

ST317

4611

6874

4611

6874

MS21042L08
Nut

Purchased No

120 Each 854.0000

22

44 JB

Location

Loc Qty

Loc Code

ST300

54

121524

54

ST317

800

122141

800

MS21042L3
Nut

Purchased No

120 Each 3,324.0000

2

4 JB

Location

Loc Qty

Loc Code

ST300

1324

117885

32

119017

771

119075

138

121444

383

ST317

2000

122141

2000

122141

12/08/29

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 86578
Parent Item: D350-600-249
Parent Item Name: Spacepod Upgrade

Start Date: 7/05/12

Required Date: 7/09/12

Start Qty: 2.00

Required Qty: 2.00

MS21042L5

Nut

Purchased

No

120

Each

1,218.0000

2

✓ JB

88

Location

Loc Qty

Loc Code

300

500

121652

500

121652

ST300

718

108827

4

116105

5

116548

43

119109

654

17651

4

2937

8

MS24694-S69

Screw

Purchased

No

120

Each

60.0000

2

✓ JB

88

Location

Loc Qty

Loc Code

ST289A

60

112492

60

112492

MS27039-08-11

Screw

Purchased

No

120

Each

59.0000

4

✓ JB

88

Location

Loc Qty

Loc Code

ST290

7

117441

7

117441

ST292

52

116289

2

120833

50

120833

MS27039-1-25

Screw

Purchased

No

120

Each

51.0000

2

✓ JB

12/08/29

Location

Loc Qty

Loc Code

ST292

51

102602

51

102602

July-05-12 1:10:16 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 6

Work Order ID: 86578

Parent Item: D350-600-249

Start Date: 7/05/12

Required Date: 7/09/12

Parent-Item Name: Spacepod Upgrade

Start Qty: 2.00

Required Qty: 2.00

NAS1515H3

Purchased

No

120

Each

130.0000

2

4

JB

12/08/29

Washer

502

Location

Loc Qty

Loc Code

ST277

130

119438

2

120518

26

121415

98

121649

4

121415

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X									D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
	1			X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-449	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
									D2464-0360	NEOPRENE SEAL
			1	1					D2589	KEYS, KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	1		D3015-3	LOCK NUT
			1		1				D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	1		D3547-17	BRACKET
1	1	1			1	1	1		D3550-17	STRUT
			1	1	1	1	1		D3552-7	GAS SPRING
1	1	1			1	1	1		D3554-7	BALL STUD
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	1		AN5-5A	BOLT
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	4		AN526C832R14	SCREW
7	7	7							MS24694S67	SCREW
1	1	1			1	1	1		MS24694S69	SCREW
			2	2	2	2	2		MS27039-0811	SCREW
8	8	8			1	1	1		AN3235-020-935	WASHER
8	8	8							AN960JD10	WASHER
16	16	16			1	1	1		AN960JD10L	WASHER
			4	4	8	8	8		AN960JD8	WASHER
3	3	3			3	3	3		AN960JD516	WASHER
			2	2	2	2	2		NAS1515H3	NYLON WASHER
			2	2	6	6	6		MS21042L08	NUT
16	16	16			1	1	1		MS21042L3	NUT (or MS21042-3)
1	1	1			1	1	1		MS21042L5	NUT
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT
								3	M81824/1-2	SPLICE

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Revision: E

Date: 09.07.31

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
								2	D3597-1	FEMALE SPADE CONNECTOR
								1	D3598-2-096	EXPANDABLE SLEEVE
								24	D3599-1	TIE-WRAP
								24	D3600-1	TIE-WRAP MOUNT
								24 FT	M22759/16-22-9	WIRE
			1*	1*	1*	1*			D2464-1250	NEOPRENE SEAL
1**		1**	1*		1*				D3567-1	DECAL
	1**			1*		1*			D3567-2	DECAL
			2*	2*					D2586	LATCH
			2*	2*					D2585	MOUNTING CHANNEL
			2*	2*					D2621	LATCH PLATE
			2*	2*					MS27039-1-15	SCREW
					2	2	1		MS27039-1-25	SCREW
			2*	2*	2	2	1		AN960JD10	WASHER
			2*	2*	2	2	1		MS21042L3	NUT (or MS21042-3)
			1*	1*					D2857-1	HINGE BRACKET
			1*	1*					D2857-2	HINGE BRACKET
			2*	2*					D2228	BACKING PLATE
			8*	8*	8	8	8		AN526C832R10	SCREW
			8*	8*	8	8	8		AN960JD8	WASHER
			8*	8*	8	8	8		MS21042L08	NUT
			1*	1*	1*	1*	1		D3557-1	BRACKET
			2*	2*	2*	2*	2		D2228	BACKING PLATE
			1*	1*	1*	1*	1		D3554-7	BALL STUD
			1*	1*	1*	1*	1		AN960JD516	WASHER
			1*	1*	1*	1*	1		D3015-3	LOCK NUT
			2*	2*	2*	2*	2		AN526C832R14	SCREW
			2*	2*	2*	2*	2		AN526C832R10	SCREW
			4*	4*	4*	4*	4		AN960JD8	WASHER
			4*	4*	4*	4*	4		MS21042L08	NUT
2**	2**	2**			1	1	1		D2237	STRIKER PLATE
4**	4**	4**			2	2	2		MS20426AD4.5	RIVET
2**	2**	2**			2	2	2		D3538-1	HINGE BRACKET
2**	2**	2**							D2179	HINGE BRACKET PLATE
4**	4**	4**			4	4	4		AN526C832R24	SCREW
4**	4**	4**			4	4	4		AN960JD8	WASHER
4**	4**	4**			4	4	4		MS21042L08	NUT

* PRE-INSTALLED ON D3186-3/-4 SPACEPOD™ DOOR

** PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD™

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